

Date: Monday, 22/10/2007 2:17:12 PM
User: Linda Lacelle

Process Sheet

Split

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 35295-1					
Estimate Number	: 12578					
P.O. Number	:					
This Issue	: 22/10/2007	S.O. No.	:	Part Number	: D3560041	
Prsh Rev.	: NC			Drawing Number	: D3560 UNDER REVIEW	
First Issue	: //	Type	: SMALL /MED FAB	Project Number	: N/A	
Previous Run	: 35029			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 29/10/2007	
Comment	: Est Rev:A New Issue 07.05.24 EC est rev B ECN 987 07.10.09 EC verified by: DD			Qty:	14 Um: Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"

Comment: Qty.: 1.4648 f(s)/Unit Total: 20.5065 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M105950



2.0	BAND SAW	BAND SAW	3.L 04/10/24 (12)

Comment: BAND SAW
Cut blanks 16.750" long



3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	3.L 04/10/24 (12)

Comment: HAAS CNC VERTICAL MACHINING #1



1- Mill as per Folio FA693 Rev: A & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	SD/BC 02.10.24 (12)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/BC 02.10.24 (12)



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Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

25/07/12/31

6.0 D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

PLATE 3 35331 3 35331 ✓ P08.08.14 (10) 25/07/11/29

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

HSP

2- set up bracket and arm on jig

SP SP

3- preheat bracket and arm with torch

SP SP

4- clean before welding with brush

SP SP

5- set up machine to 135 amps

SP SP

6- weld across bottom and top ends

SP SP

7- reheat with torch (

SP SP

8- on one side weld from bottom to top half way

SP SP

9- same for other side (half way)

SP SP

10- from half way point weld the rest of the first side (ease off pedal near end)

SP SP

11- same for remaining side (ease off pedal near end)

SP SP

SP 08.08.14 (10)

25/07/11/29

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

VISUAL WELDING INSPECTION

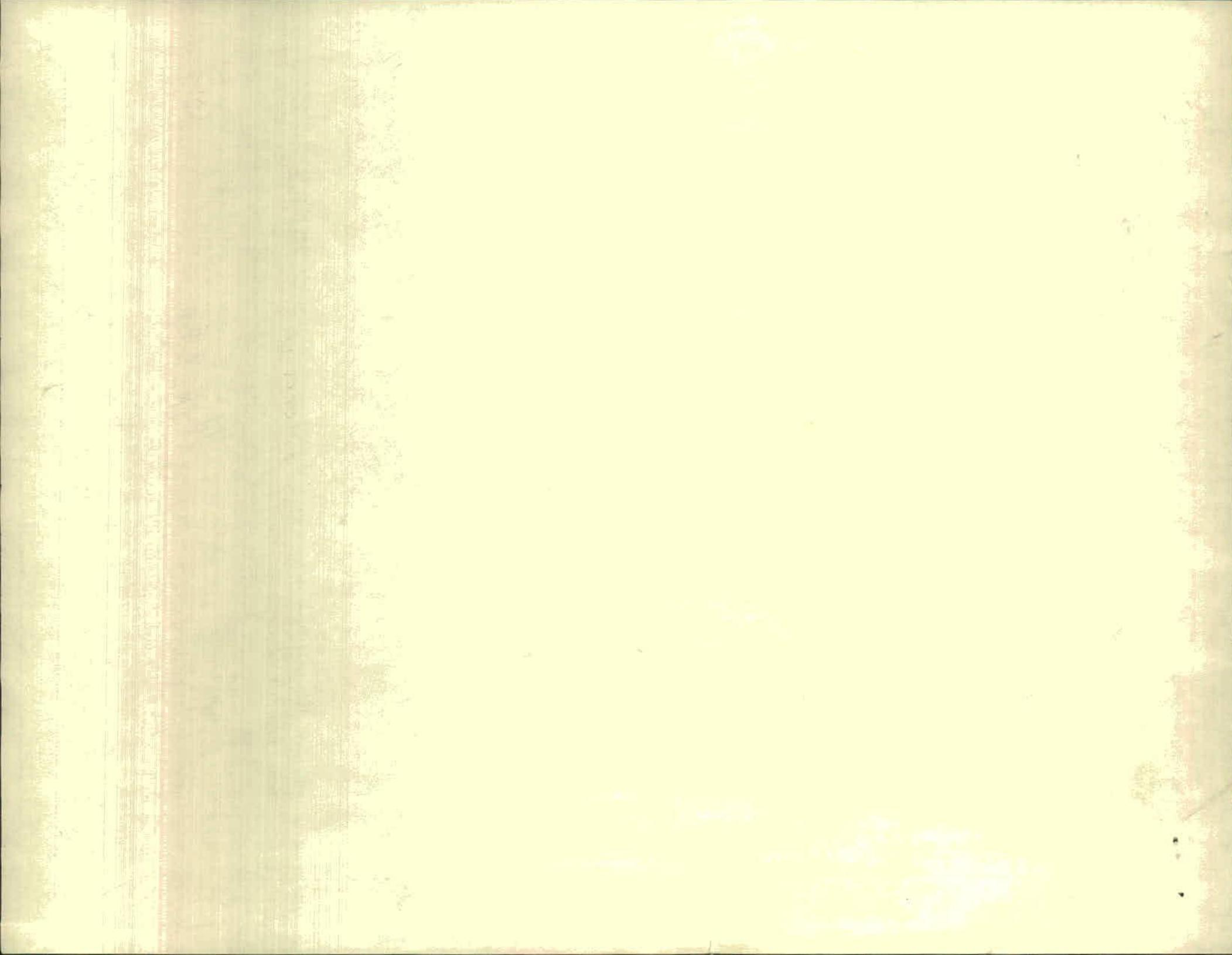
Pd 08.08.15



(X1)

Comment: VISUAL WELDING INSPECTION

M08/08/15



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Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation:

10.0 HAND FINISHING1

Description :

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP 08.08.5 (1)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 D2808

Spacer

SB 08/08/18 (1)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Spacer

batch: B37 113

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

SB 08/08/18 (1)

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/08/18 (1)

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

PL 08.08.18 (1)

16.0 QC21

FINAL INSPECTION/W/O RELEASE



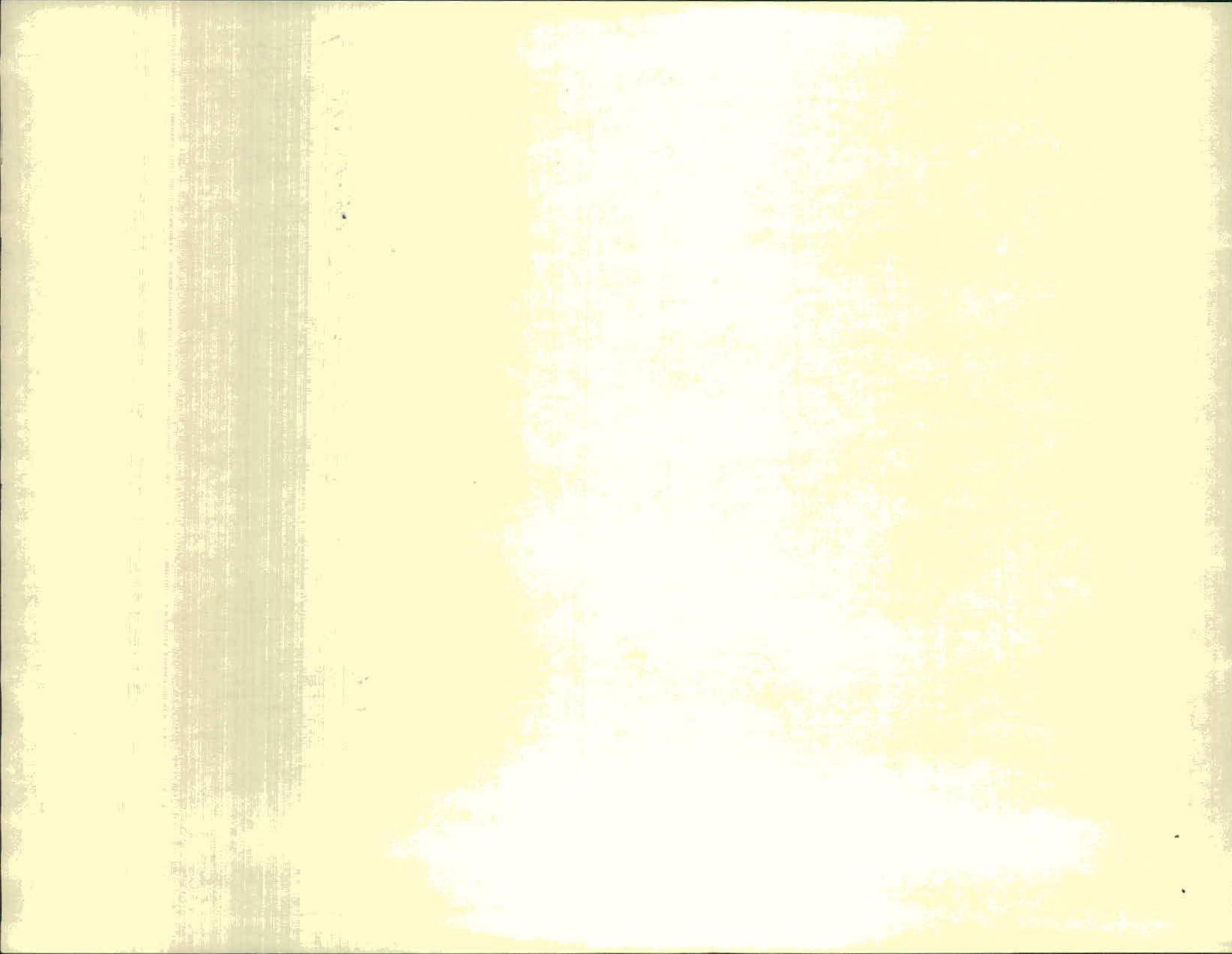
Comment: FINAL INSPECTION/W/O RELEASE

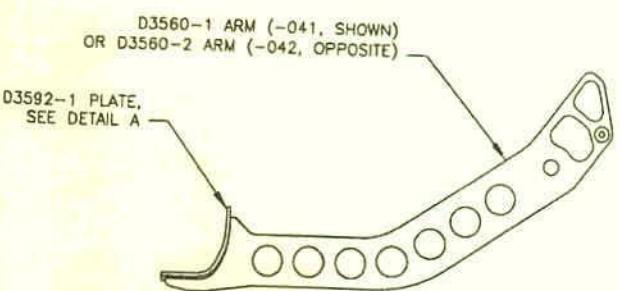
08/08/19 (1)

Job Completion

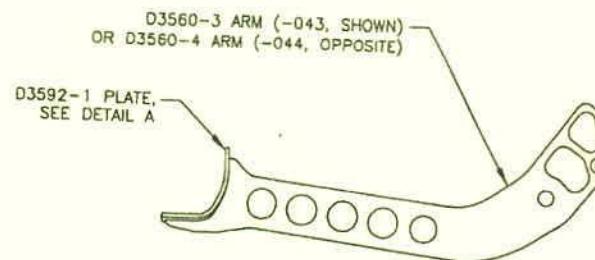


MF 08-08-18

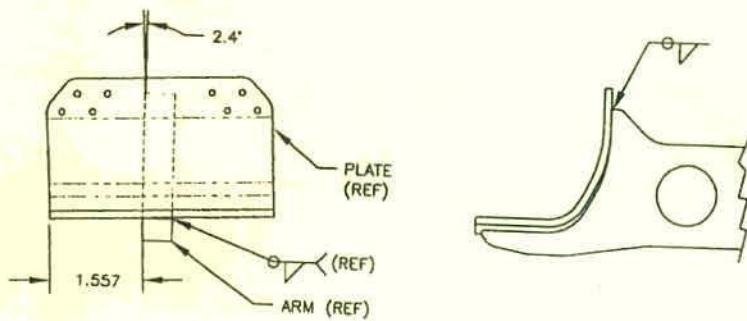




D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

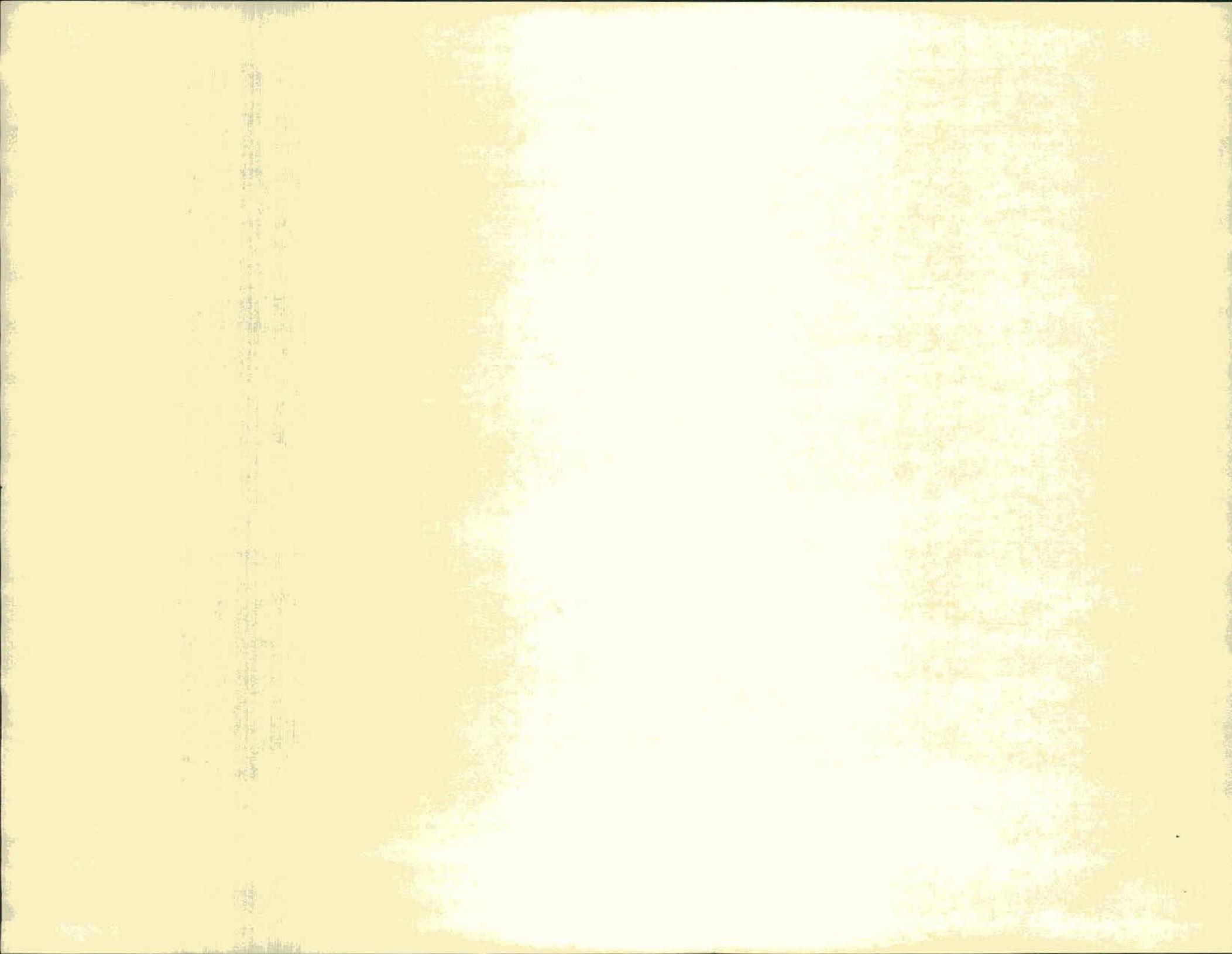
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07.06.19

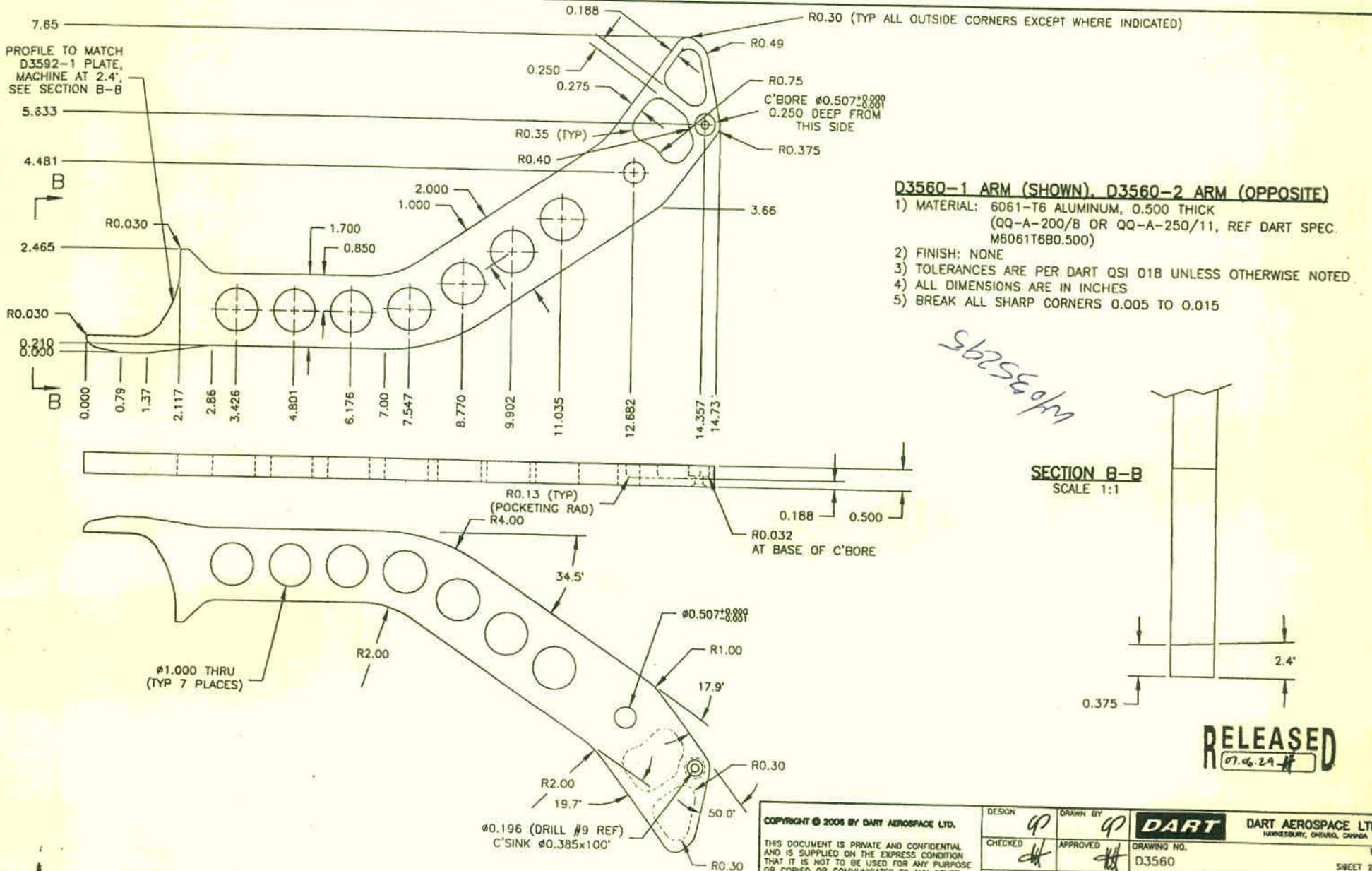
UNDER REVIEW

07.10.22 DE

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	
CHECKED	APPROVED	DART
		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DATE	TITLE	REV. C SHEET 1 OF 3 SCALE 1:4
07.06.19	ARM WELDMENT	

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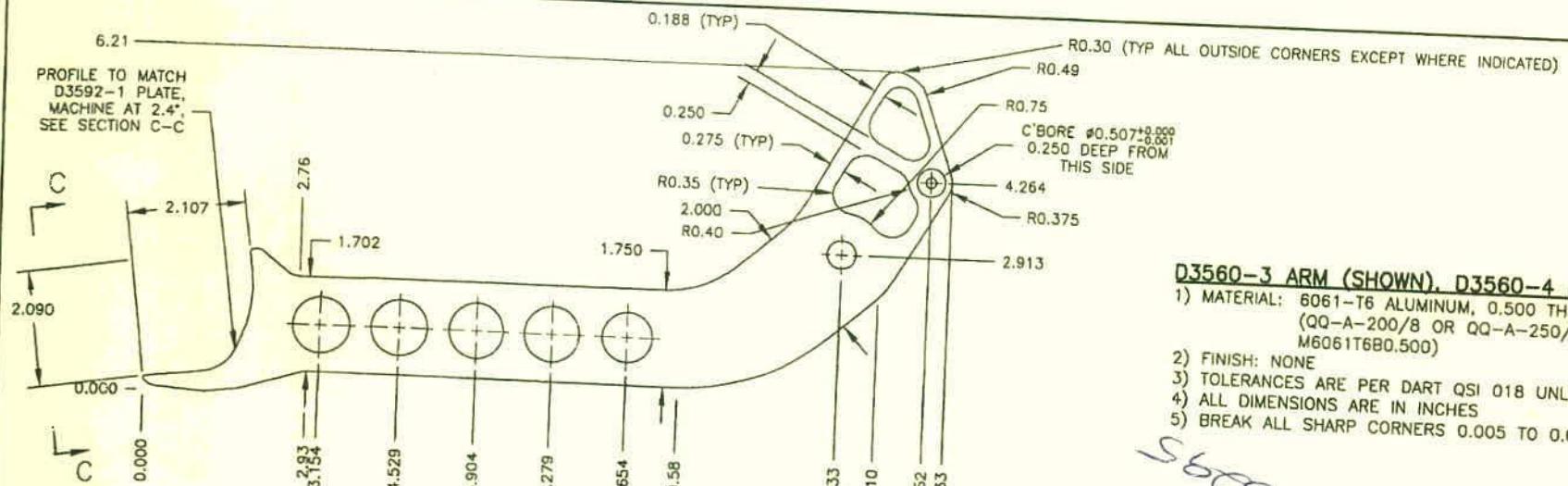




DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D3560
DATE			SHEET 2 OF 3
07.06.19			TITLE ARM WELDMENT
			SCALE 1:2

RELEASED
07.06.29

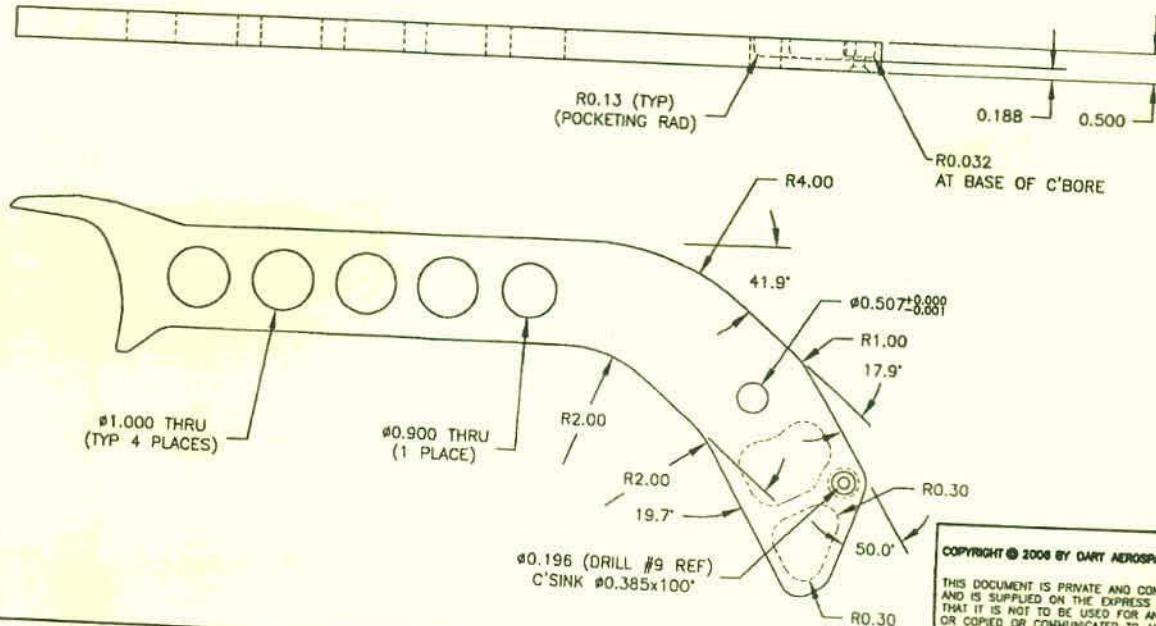




D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

Section C-C



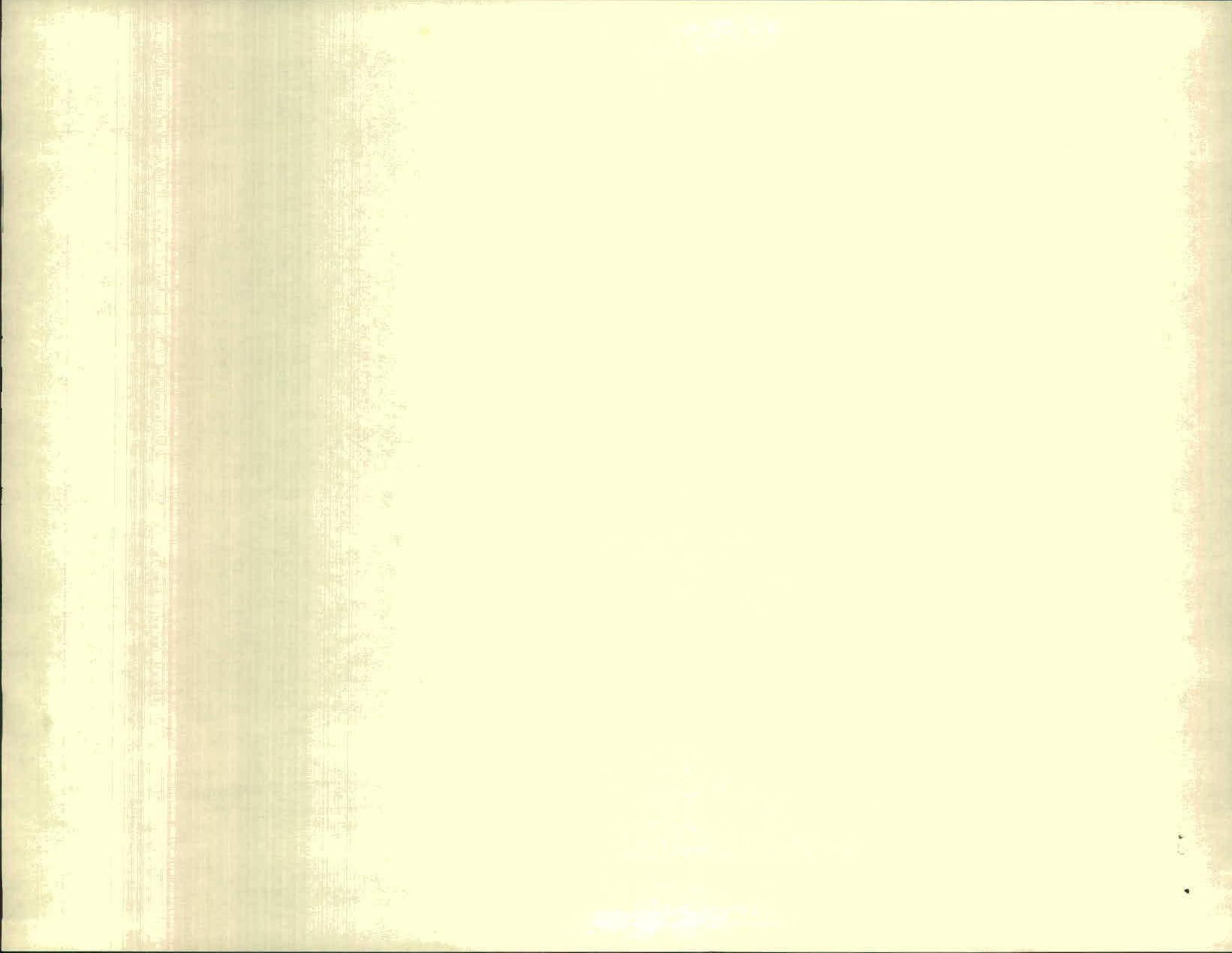
SECTION C-C
VIEW ROTATED
SCALE 1:1

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07.06.29

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D3560
DATE			SHEET 3 OF 3
07.06.19			SCALE 1:2
			TITLE ARM WELDMENT



DART AEROSPACE LTD	Work Order:	35295
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B.L.</u>	Audited by:	<u>J-L</u>	Prototype Approval:	N/A
Date:	07/10/29	Date:	07/10/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

